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(11) Publication number:

**0 630 640 A1**

(12)

## EUROPEAN PATENT APPLICATION

(21) Application number: **94109740.4**

(51) Int. Cl.<sup>5</sup>: **A61K 6/083, A61K 6/09**

(22) Date of filing: **23.06.94**

(30) Priority: **23.06.93 US 81940**  
**16.05.94 US 240857**

(43) Date of publication of application:  
**28.12.94 Bulletin 94/52**

(84) Designated Contracting States:  
**CH DE ES FR GB IT LI SE**

(71) Applicant: **DENTSPLY INTERNATIONAL INC.**  
**570 W. College Avenue**  
**York,**  
**Pennsylvania 17404 (US)**

(72) Inventor: **Tateosian, Louis H.**  
**209 Reynolds Mill Road**  
**York, PA 17403 (US)**  
Inventor: **Shaffer, Scott E.**  
**20 Farmington Drive**  
**Jacobus, PA 17407 (US)**  
Inventor: **Latta, Mark A.**  
**404 White Rose Lane**  
**York, PA 17402 (US)**

(74) Representative: **Wächtershäuser, Günter, Prof.**  
**Dr.**  
**Patentanwalt**  
**Tal 29**  
**D-80331 München (DE)**

(54) **Dental composition, prostheses and method for making dental prostheses.**

(57) A dental prosthesis includes polymeric material formed by heat curing a polymerizable composition having at least 5 percent by weight of at least one polymerizable Monomer having at least one acrylic moiety and a gram molecular weight of at least 200. The polymeric material is preferably formed by heat curing and has an unnotched Izod impact strength of at least 2.5 and more preferably at least 3.0 ft• lb/in as measured by a Modified ASTM D256, and a flexural fatigue life of at least 20,000 flexes to failure at 0.1 inch deflection. Preferably the polymerizable monomer has a vapor pressure less than 5 mm Hg at 23 °C. A method of making a denture is provided which includes molding and polymerizing the polymerizable composition to form a denture. Preferably the polymerizable composition includes polymerizable compounds made up of at least 5 percent by weight of the acrylic Monomer having a gram molecular weight of at least 300 and less than 5 percent by weight of Volatile compounds and less than 2 percent by weight of Low Molecular Weight acrylic compounds having a gram molecular weight of less than 200.

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The invention relates to compositions and methods for making dental prostheses. The invention provides dental prostheses formed from one-component heat curable compositions without Volatile Monomers such as methyl methacrylate which form dental prostheses having high impact strength, and a method of making dental prostheses therefrom without the need for mixing i.e., a one-component system.

5 Dental prostheses made in accordance with a preferred embodiment of the invention include polymeric material which is formed from a composition having at least 5 percent by weight of acrylic Monomers having at least one or more preferably at least two acrylic moieties having a gram molecular weight of at least 200 and more preferably at least 300, polymer particles which are readily reactive with, swollen by, or  
10 superficially dissolved by the acrylic Monomer and less than 10 percent by weight more preferably less than 5 percent by weight and most preferably less than 2 percent by weight Low Molecular Weight Monomer. Dental prostheses in accordance with the invention preferably having an unnotched Izod impact strength of at least 2.5 and more preferably at least 3.0 ft · lb/in measured by Modified ASTM D256, and at least 20,000 and more preferably at least 50,000 flexes to failure using the Flexural Fatigue of Denture Bases Test. Dental prostheses of the invention include denture base, artificial teeth, fillings, inlays, crowns  
15 and bridges.

Cornell in U.S. Patent 3,427,274 disclose impact resistant alkali-washed mixed butadiene-styrene and methyl methacrylate molding composition. Birger in U.S. Patent 3,435,012 discloses anaerobic sealant composition containing monoacrylate esters. Petner in U.S. Patent 3,470,615 discloses dental crowns faced with polyglycol dimethacrylate and process for making. Petner in U.S. Patent 3,471,596 discloses process  
20 of making fused thermosetting dental objects. Dougherty in U.S. Patent 3,647,498 discloses process for production of dental crowns. Bernd et al in U.S. Patent 3,661,876 disclose adhesives or sealing agents which harden on exclusion of oxygen. Millet in U.S. Patent 3,808,687 discloses method of making dental restorations and pontic member therefor. Dougherty in U.S. Patent 3,889,385 discloses liquid dental opaquer and method. Matsuda et al in U.S. Patent 3,899,382 discloses anaerobic bonding agent. Kose et al  
25 in U.S. Patent 3,969,433 disclose iridescent composition and the process of preparing the same. Behrens in U.S. Patent 4,092,303 discloses polyacrylate elastomers with improved elasticity. Lee, Jr. et al in U.S. Patent 4,104,333 disclose self-curing artificial fingernails. Alderman in U.S. Patent 4,115,922 discloses dental crown and bridge shading system. Hess in U.S. Patent 4,129,611 discloses thermoplastic polyurethanes of mixtures of hard and soft thermoplastic polymers. Lee, Jr. et al in U.S. Patent 4,229,431 discloses method

denture base. Bunyan in U.S. Patent 4,331,580 discloses flowable anaerobic sealant composition. Podoszinski et al in U.S. Patent 4,394,465 disclose dental materials based on organic plastics in paste form. Roemer et al in U.S. Patent 4,396,476 disclose blend of cross-linked polymer, swelling monomer and cross-linking agent and curing process. Roemer et al in U.S. Patent 4,396,477 disclose dental appliances having  
35 interpenetrating polymer networks. Alberts et al in U.S. Patent 4,427,809 disclose thermoplastic molding compositions of co-graft polymers. Werber in U.S. Patent 4,431,787 discloses anaerobic adhesives. Callander in U.S. Patent 4,433,077 discloses process for preparing curable compounds. Kawahara et al in U.S. Patent 4,454,258 disclose resin-forming material, implant material and compositions for restorative material suitable for medical or dental use. Blair et al in U.S. Patent 4,533,325 disclose method and  
40 apparatus to produce artificial teeth for dentures. Blair in U.S. Patent 4,551,098 discloses method and apparatus to produce artificial teeth. Tateosian et al in U.S. Patent 4,551,486 disclose interpenetrating polymer network compositions. Schaefer in U.S. Patent 4,563,153 discloses dental composition containing pigment and methods of using the same. Ratcliffe et al in U.S. Patent 4,602,076 disclose photopolymerizable compositions. Blair in U.S. Patent 4,609,351 discloses apparatus to produce artificial dentures. Milnes et al  
45 in U.S. Patent 4,650,550 discloses manufacture and repair of dental appliances. Blackwell et al in U.S. Patent 4,657,941 disclose biologically compatible adhesive containing a phosphorus adhesion promoter and a sulfinic accelerator. Ibsen et al in U.S. Patent 4,674,980 disclose dental composite and porcelain repair. Denyer et al in U.S. Patent 4,689,015 disclose dental compositions. Tateosian in U.S. Patent 4,698,373 discloses stable one part dental compositions employing IPN technology. Cornell in U.S. Patent 4,704,303  
50 discloses nail extension composition. Blair in U.S. Patent 4,705,476 discloses method and apparatus to produce artificial dentures. Tateosian et al in U.S. Patent 4,711,913 disclose interpenetrating polymer network compositions employing rubber-modified polymers. Engelbrecht in U.S. Patent 4,771,112 discloses compounds that consist of aldehyde, epoxide isocyanate, or halotriazine groups of polymerizable groups, and of a higher-molecular backbone, mixtures that contain them, and the use thereof. Engelbrecht et al in  
55 U.S. Patent 4,806,381 disclose polymerizable compounds containing acid and acid derivatives, mixtures containing the same, and use thereof. Blackwell et al in U.S. Patent 4,816,495 disclose biologically compatible adhesive visible light curable compositions. Kashihara et al in U.S. Patent 4,842,936 disclose composite basic resin particles, its preparation and resinous composition for coating use containing the

same. Tateosian et al in U.S. Patent 4,863,977 disclose process for preparing interpenetrating polymer network objects employing rubber-modified polymers. Engelbrecht in U.S. Patent 4,872,936 discloses polymerizable cement mixtures. Mori et al in U.S. Patent 4,880,857 disclose carbon black-graft polymer, method for production thereof, and use thereof. Tateosian in U.S. Patent 4,892,478 discloses method of preparing dental appliances. Nakamura in U.S. Patent 4,928,403 discloses plastic heels of shoes and boots. Wolf, Jr. in U.S. Patent 4,938,831 discloses bonding method for preparing automotive headlamp assemblies. Mori et al in U.S. patent 4,940,749 disclose carbon black-graft polymer method for production thereof, and use thereof. Mori et al in U.S. patent 4,994,520 disclose carbon black-graft polymer, method for production thereof, and use thereof. Antonucci et al in U.S. Patent 5,037,473 disclose denture liners. Omura in U.S. Patent 5,091,441 discloses dental composition. Tateosian et al in U.S. Patent 5,210,109 disclose interpenetrating polymer network compositions employing rubber-modified polymers. Blackwell in U.S. Patent 5,218,070 discloses dental/medical compositions and use. Ying in Canadian Patent 1,259,149 discloses dental restorative composition containing monofunctional monomer. Howard et al in Canadian Patent 1,102,039 disclose radiation curable coating compositions containing unsaturated addition - polymerizable urethane resin. Suling et al in Canadian Patent 1,145,880 disclose molded dental pigments. Denyer et al in Canadian Patent 1,148,294 disclose dental compositions Ikeda et al in Canadian Patent 1,149,538 disclose curable resin compositions. Ratcliffe et al in Canadian Patent 1,189,996 disclose polymerizable dental composition containing a mixture of fine particle size and large particle size fillers. Fellmann et al in Canadian Patent 1,200,046 disclose permanent dental restorative material. Michael et al in Canadian Patent 1,209,298 discloses photopolymerizable composition especially for dental purposes. Ibsen et al discloses in Canadian Patent 1,243,796 dental composite and porcelain repair. Ibsen et al in Canadian Patent 1,244,177 discloses methacrylate functional resin dental composite and porcelain repair compositions. Schaefer in Canadian patent 1,244,581 discloses priming material for plastic dental members. Randklev in Canadian Patent 1,245,437 discloses radiopaque low visual opacity dental composites containing non-vitreous microparticles. Waknine in Canadian patent 1,262,791 discloses two component (Paste-Paste) self curing dental restorative material. Okada et al in Canadian Patent Application 2,002,017 disclose dental restorative material. Heid et al in Canadian Patent Application 2,009,471 discloses hybrid plastic filling material. Mitra et al in Canadian Patent Application 2,032,773 disclose dental compositions, a method of making shaped dental articles via photoiniferter polymerization of the dental compositions, and shaped dental articles produced thereby. Holmes in Canadian Patent Application 2,033,405 discloses dental material containing anti-slump additive. Rheinberger in Canadian Patent Application 2,051,333 discloses polymerizable dental material. Tateosian et al in European Patent Application 0 334 256 A2 disclose dental appliance preparation and material therefor. Muramoto et al in European Patent Application 0 185 431 A3 disclose composite resin particles, its preparation and resinous composition for coating use containing the same. Kuboto et al in U.K. Patent Application GB 2,189,793A disclose Polymerizable compositions for dental restoration. Heynold et al in PCT/DE87/00135 discloses polymerizable mass for production of non-hardening moulded elements, particular of dental prostheses. Luxatemp - Automix discloses a cartridge for polymerization. DMG HAMBURG discloses paste containing cannulas. Morrow et al disclose waxing and processing in Dental Laboratory Procedures, Volume One 1986, pages 276-311. Miller discloses acrylourethane resin design in Radiation Curing at pages 4, 6, 8, 9. Sartomer discloses urethane acrylate in Product Bulletin, 12 pages. Miller discloses monomers in Rubber & Plastics Research Abstracts, 6 pages. Sartomer discloses aliphatic and aromatic urethane acrylates in Oligomer Product Guide, 3 pages. Sartomer discloses in low skin irritation monomers in Sartomer Company, 4 pages. Sartomer discloses monomers, oligomers, and photoinitiators in Product Catalog, pages 18-21. Advanced Plasma Systems, Inc. discloses new D-series table-top gas plasma system, 4 pages. Dentsply discloses technique manual and operation/service manual in Triad<sup>®</sup> VLC System, 3 pages. Wilson et al, Flexure Fatigue of Denture Bases, Journal of Dental Research, 1988, International Association for Dental Research.

The prior art does not provide a dental prosthesis made of a polymeric material having an unnotched Izod impact strength of at least 3.0 as measured by Modified ASTM D256, and 20,000 flexes to failure using the Flexural Fatigue of Denture Bases Test, formed by heat curing a one-component polymerizable composition including at least 5 percent by weight of at least one polymerizable acrylic Monomer, having at least one and more preferably at least two acrylic moieties and a gram molecular weight of at least 200 and more preferably at least 300 as is provided by the present invention.

It is an object of the invention to provide a method of making a prosthesis by providing polymerizable composition including particulate polymer and at least 5 percent by weight of acrylic Monomers at least one and more preferably at least two acrylic moieties and a molecular weight greater than 200 and more preferably greater than 300 and a vapor pressure less than 5 mm at 23°C, molding and heat curing said polymerizable composition to form a prosthesis with an impact strength of at least 2.5 and more preferably

at least 3.0 ft•lbs/in by a Modified ASTM D256 unnotched impact strength as hereinafter described and 20,000 flexes to failure using the Flexural Fatigue of Denture Bases Test.

It is an object of the invention to provide a denture base of a polymeric material having at least 20,000 flexes to failure using the Flexural Fatigue of Denture Bases Test formed by heat curing at least one polymerizable Monomer having at least one and more preferably at least two acrylic moieties and a gram molecular weight of greater than 200 and more preferably greater than at least 300.

Prosthesis as used herein refers to dental replacement parts and ancillary materials including dentures, fillings, crowns, bridges, teeth, and also dental restorative materials including filling and inlays.

"Volatile" as used herein refers the compounds having a vapor pressure greater than 5mm Hg at 23 °C, for example methyl methacrylate.

"Non-Volatile" as used herein refers the compounds having a vapor pressure less than 5mm Hg at 23 °C.

"Flexural Fatigue of Denture Bases Test" as used herein refers to the test described by Wilson, W.D., Tateosian, L.H., Grunden, C.J., Wagner, R.L., Flexural Fatigue of Denture Bases, J. Dent. Res. 67:196, 1988. The flexural fatigue of a denture base material is studied by subjecting a rectangular-shaped specimen to repeated bending on a four-way bending machine. The specimen is supported at both ends and the load is applied at the midpoint to bend the sample. The specimen is tested until failure by continuous cycling on the machine which bends the sample first in one direction, then in the opposite direction. This is called a four-way cycle; one cycle gives two flexes. The cycling speed is 100 cycles per minute (200 flexes per minute) which is reported to be approximately twice the chewing speed of a "normal" individual. The bend or deflection distance is set to 0.1 inch to exaggerate the movement which occurs when a denture is used in-the-mouth. A counter records each cycle and the machine stops when the specimen breaks. The number of cycles to failure is recorded for each specimen and the median number of flexes to break is calculated for each material. The material with the higher number of flex cycles until break is the more desirable material.

"Modified ASTM D256" as used herein refers to ASTM D256 conducted using unnotched samples which are 2.85 x 11 x 85 mm.

"Low Molecular Weight" as used herein refers to gram molecular weight less than 200, for example, methyl methacrylate.

"Diluent Monomers" as used herein refers to monomers having a viscosity of less than about 1000 cps measured at 23 °C measured by ASTM D2393-68 and gram molecular weights in the range of 200 to 600.

"Catalyst" as used herein includes free radical generating polymerization initiators.

### Summary of the Invention

A dental prosthesis includes polymeric material formed by heat curing a polymerizable composition having at least 5 percent by weight of at least one polymerizable Monomer having at least one acrylic moiety and a gram molecular weight of at least 200. The polymeric material is preferably formed by heat curing and has an unnotched Izod impact strength of at least 2.5 and more preferably at least 3.0 ft•lb/in as measured by a Modified ASTM D256, and a flexural fatigue life of at least 20,000 flexes to failure at 0.1 inch deflection. Preferably the polymerizable monomer has a vapor pressure less than 5 mm Hg at 23 °C. A method of making a denture is provided which includes molding and polymerizing the polymerizable composition to form a denture. Preferably the polymerizable composition includes polymerizable compounds made up of at least 5 percent by weight of the acrylic Monomer having a gram molecular weight of at least 300 and less than 5 percent by weight of Volatile compounds and less than 10 percent by weight more preferably less than 5 percent by weight and most preferably less than 2 percent by weight of Low Molecular Weight acrylic Monomer having a gram molecular weight of less than 200.

### Detailed Description of the Invention

A preferred embodiment of the invention is now described with more particular reference to a dental prosthesis made of polymeric material. The polymeric material is formed from a polymeric particles and at least one polymerizable Monomer having at least one or more preferably at least two acrylic moieties, and a gram molecular weight of at least 200 and more preferably at least 300. The polymeric material has an unnotched Izod impact strength of at least 2.5 and more preferably at least 3.0 ft•lb/in as measured by Modified ASTM D256, and a flexural fatigue life of at least 20,000 flexes to failure as measured by the Flexural Fatigue of Denture Base Test. Preferably the polymerizable Monomer has a vapor pressure less

than 5 mm Hg at 23 °C.

Preferably compositions in accordance with the invention have less than one percent by weight of Low Molecular Weight acrylic Monomers; more preferably compositions in accordance with the invention are substantially free of all Low Molecular Weight of acrylic Monomers.

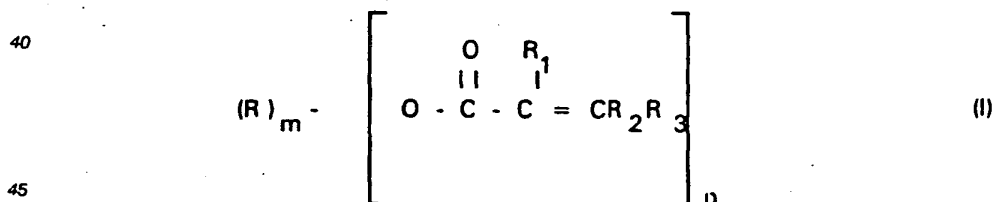
5 In accordance with a preferred embodiment of the invention a denture flask is prepared for subsequent denture fabrication by the lost-wax technique following ordinary techniques by those skilled in the art. The denture mold is coated with separating agents, such as, Al-Cote® separating agent and/or Dent-Kote® separating agent, each sold by Dentsply International, Inc. Methyl methacrylate or other bonding agent is applied to the plastic teeth as the bonding agent. The mold is preferably made from Castone® Dental  
10 Stone, sold by Dentsply. The mold is placed in a metal container referred to as a flask. The mold contained within the flask is then packed with the one-component (ready-to-use) heat-curable denture base material in accordance with the invention. The mold is closed and pressed to complete the compression-pack step. After clamping in a spring clamp, the mold is placed into a curing tank. The cure cycle is one and one half hours at 163 °F (73 °C) followed by a 1/2 hour at 212 °F (100 °C). After removing the cured denture from the  
15 mold (de-flasking), the denture is finished (trimmed and polished).

The heat-curable denture material of the invention preferably forms a composite comprised of polymer particles and may include submicron silica filler in an acrylourethane resin matrix. The filler serves to increase viscosity and provide useful characteristics of the composition. Useful heat-cure initiators include dibenzoyl peroxide (BPO), tert-butyl perisononanoate (TBPIN) and/or benzopinacol.

20 Polymerization of compositions in accordance with the invention is preferably initiated at a temperature of about 115 °F to 240 °F, more preferably from about 140 °F to 220 °F and most preferably from about 160 ° to 212 °F. The polymerization (heat cure) time is preferably from about 15 minutes to about 24 hours, more preferably from about 30 minutes to about 15 hours, and most preferably from about 1 hour to about 9 hours. Polymerization of compositions in accordance with the invention is preferably initiated at a  
25 temperature of about 163 °F when using benzyl peroxide (BPO) as the catalyst and at a temperature of about 212 °F when using TBPIN/benzopinacol as the catalyst. Polymerization is preferably initiated in a cure tank containing hot water. Preferably solid catalysts, such as BPO have a particle size of less than 20 microns. More preferably the catalyst(s) have a particle size of less than 15 microns.

TBPIN/benzopinacol are preferred catalysts for increased thermal stability. The denture composition of  
30 the invention is preferably provided in bulk packaging, for example, 300 to 500 grams of the denture material.

Polymerizable acrylic compounds useful in accordance with the invention include compounds within the scope of general formula (I) of which have a gram molecular weight of at least 200 and more preferably at least 300 are adapted to form polymeric material having an unnotched Izod impact strength of at least about  
35 3.0 ft·lb/in and more preferably at least 3.5 ft·lb/in most preferably at least 4.0 ft·lb/in as measured by Modified ASTM D256:



wherein R is an acrylic-free organic moiety which is at least 60 grams per molecule, R<sub>1</sub> is hydrogen, halogen, alkyl, substituted alkyl or cyano radical, R<sub>2</sub> and R<sub>3</sub> each independently is hydrogen or halogen and  
50 n is an integer from 1 to 6 and m is an integer from 1 to 1000, R is a organic spacer unit such as one or more of alkyl, cycloaliphatic, aryl, polyether, urethane, polyurethane or polyester, including forms thereof substituted with one or more halogen atoms, carboxyl, phosphoric and other acid moieties and esters and salts thereof. Preferably m is one.

Preferred monomers, oligomers and prepolymers for use in accordance with the invention includes  
55 acrylated polyurethane oligomers with polyester or polyether soft segments and cycloaliphatic urethane hard segments, urethane di(meth)acrylates and low viscosity (less than 1,000 cps at 23 °C) diluent monomers. Polymerizable acrylated polyurethane oligomers are waxy, syrupy or mobile liquids. In a preferred embodiment of the invention a polymerizable dental paste composition includes at least one

acrylated polyurethane monomer, oligomer, or prepolymer, such as Uvithane 783, Uvithane 893 or Uvithane 892 each sold by Morton International; or Craynor CN 961, Craynor CN 962, Craynor CN 963, Craynor CN 964, Craynor CN 966, Craynor CN 971, Craynor CN 973, Craynor CN 980 or Craynor CN 981 sold by Sartomer, and Mhoromer 6661-0 (chemical name: 7,7,9-trimethyl-4,13-dioxo-3,14-dioxo-5,12-diazahexadecane-1,16-diol dimethacrylate) sold by Rohm Tech. In a preferred embodiment, the composition includes one or more of the following diluent monomers, ethoxylated (3 moles of  $-\text{CH}_2\text{CH}_2\text{O}-$  per molecule) trimethylolpropane triacrylate (sold as SR454 by Sartomer), isodecyl methacrylate, 1,6-hexanediol dimethacrylate, trimethylolpropane polyoxypropylene triacrylate (6 to 9 moles of  $-\text{CH}_2\text{CH}_2\text{CH}_2\text{O}-$  per molecule, for example, Sartomer CD 501 is 6 mole material), trimethylolpropane polyoxyethylene triacrylate (6 to 9 moles of  $-\text{CH}_2\text{CH}_2\text{O}-$  per molecule, for example, SR 499 is 6 mole material and SR 502 is the 9 mole material) and tridecyl methacrylate. Methacrylate homologs are suitable as well as acrylates. Preferably less than 30 percent by weight of low viscosity diluent monomers are added to polymerizable compositions in accordance with the invention, to adjust the resin matrix viscosity or improve the impact strength and flexural fatigue life.

The dental composition of the invention has unlimited work time, and forms polymeric products which are nonporous (no air is entrapped) and have low polymerization shrinkage.

Polymerizable acrylic compounds useful to provide polymerizable paste compositions in accordance with the invention include monofunctional monomers and multifunctional oligomers and/or monomers having di- or polyfunctional moieties which are capable of free radical, addition polymerization. In general, preferred reactive functionalities which serve as active sites for polymerization are acrylic. Monofunctional monomers include cyclohexyl methacrylate, benzyl methacrylate, methacrylate, t-butyl methacrylate, n-butyl methacrylate, isobutyl methacrylate, isodecyl methacrylate and 2-ethylhexyl methacrylate. Suitable multifunctional monomers and oligomers may be selected from numerous families of polyfunctional free radical-polymerizable monomers such as acrylic and lower alkyl acrylic acid diesters, formed from alcohols which have a different reactive functional groups, such as carboxyl and hydroxyl groups, also useful are urethane diacrylates and dimethacrylates, polyvinyl compounds, divinyl aromatic compounds, and others as will be apparent to those skilled in the art.

Preferred, multifunctional monomers and oligomers useful as polymerizable acrylic compounds in polymerizable paste compositions of the invention include esters of unsaturated acids, such as acrylic

aconitic, acids. Other unsaturated acids will be readily apparent to those skilled in the art. These acids are preferably reacted with either saturated or unsaturated polyhydroxylic alcohols to form esters which are effective multifunctional monomers and oligomers useful in the formulation of the compositions of the invention. In general, these alcohols have one or more hydroxylic functionality and have from 2 to about 30 carbon atoms. Thus, useful alcohols include allyl, methallyl, crotyl, vinyl, butenyl, isobutenyl, and similar unsaturated alcohols as well as polyols such as ethylene glycol, propylene glycol, butylene glycol, diethylene glycol, triethylene glycol, tetraethylene glycol, pentaethylene glycol, glycerol, 1,3,3-trimethylolpropane, pentaerythritol, dihydroxyphenol, and alkylidene bisphenols such as bisphenol-A, 1,1-bis (4-hydroxyphenyl) methane, 4,4'-dihydroxybiphenyl, 4,4'-dihydroxydiphenyl sulfone, dihydroxydiphenyl ether, dihydroxydiphenyl sulfoxide, resorcinol, hydroquinone, etc.

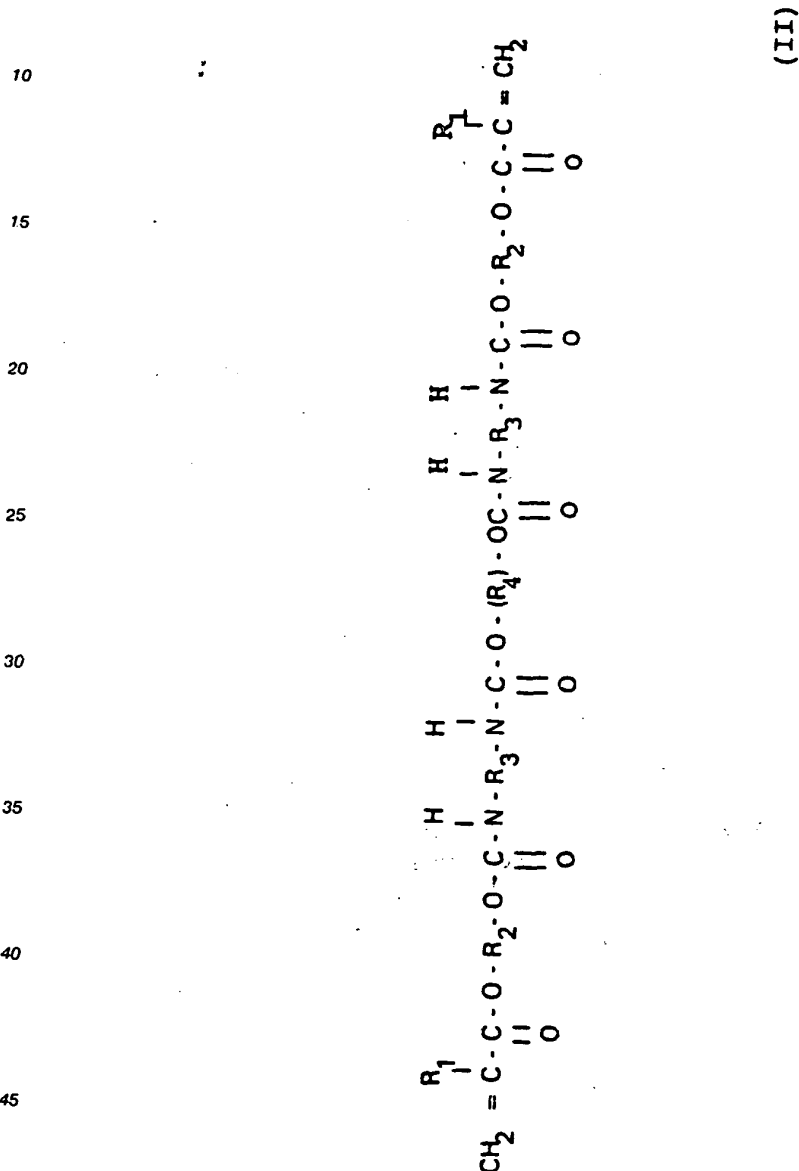
Preferred multifunctional monomers and oligomers useful as polymerizable acrylic compounds in polymerizable paste compositions of the invention include the esters of a monomeric unsaturated acids with an unsaturated mono-hydroxylic alcohol such as allyl acrylate, allyl methacrylate, dimethallyl fumarate, N-allyl acrylamide, crotyl acrylate, allyl crotonate, allyl cinnamate and diallyl maleate. Other preferred species are the di-, tri-, and higher esters of polyhydroxylic alcohols such as ethylene glycol diacrylate, trimethylolpropane tri(meth)acrylate, and the dimethacrylate ester of bisphenol-A as well as other acrylate and alkyl acrylate esters. Furthermore, mixtures of multifunctional monomers and/or oligomers are useful in the practice of the invention.

Polymerizable acrylic compounds such as bis-GMA and the urethane dimethacrylate formed from the reaction of hydroxyethyl acrylate, hydroxypropyl acrylate, and their methacrylate homologs with 2,2,4-trimethylhexyl-1,6-diisocyanate (hereinafter referred to as "urethane dimethacrylate" or "urethane diacrylate") are useful. Other diluent monomers which are useful are ethylene glycol dimethacrylate, 1,6-hexanediol dimethacrylate, ethoxylated trimethylolpropane trimethacrylate and the dimethacrylate ester of bisphenol-A and urethane adducts thereof. The corresponding acrylates are similarly useful.

Polymerizable acrylic compounds which are especially useful are oligomers are acrylated polyurethanes (also known as acrylourethane resins (or oligomers)). Preferably, the soft segment of the backbone contains polyester or polyether moiety. Preferably, the hard or urethane segment contains cycloaliphatic groups. Molecular weight of the oligomer is preferably greater than  $300 \text{ g mol}^{-1}$ , more preferably is greater than

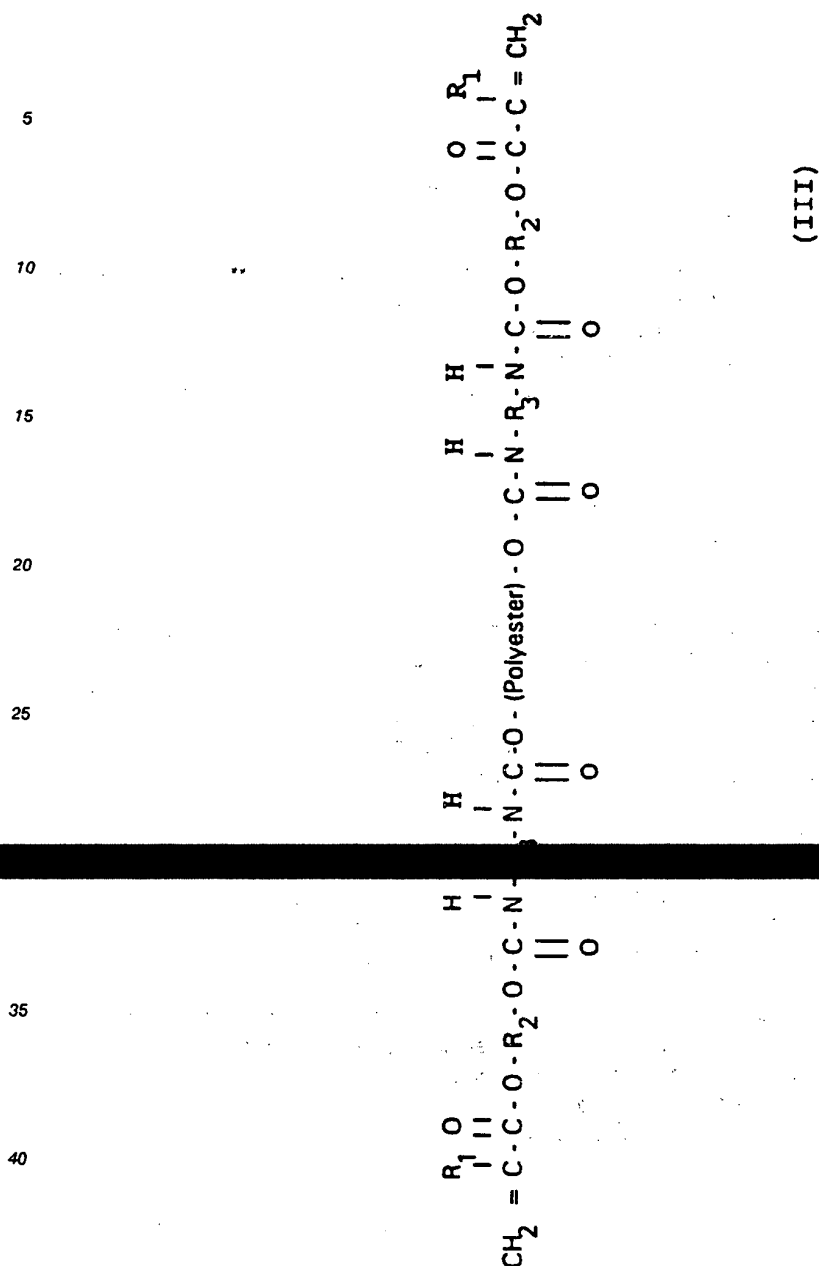
400 g mol<sup>-1</sup> and most preferably greater than 600 g mol<sup>-1</sup> with molecular weight of oligomer of more than 1,000 g mol<sup>-1</sup> or more than 5,000 g mol<sup>-1</sup> providing further reduced volatility.

In a preferred embodiment of the invention, polymerizable acrylic compounds useful in dental compositions in accordance with the invention are vinyl urethane or urethane-(meth)acrylate monomer or prepolymer materials (also known as acrylourethane resins) within the scope of the structural formula (II):



wherein each R<sub>1</sub> independently, is hydrogen, halogen, alkyl, substituted alkyl or cyano moiety, each R<sub>2</sub> independently is alkylene, substituted alkylene, cycloalkylene, substituted cycloalkylene, arylene or substituted arylene, each R<sub>3</sub> independently is alkylene, substituted alkylene, cycloalkylene, arylene, substituted arylene, heterocyclic or substituted heterocyclic, and R<sub>4</sub> is a polyester or polyether moiety (backbone or soft segment);

In a preferred embodiment of the invention, polymerizable acrylic compounds useful in dental compositions in accordance with the invention are vinyl urethane or urethane-(meth)acrylate monomer or prepolymer materials (also known as acrylourethane resins) characterized by the structural formula (III):



wherein each R<sub>1</sub> independently, is hydrogen, alkyl or substituted alkyl, R<sub>3</sub> and R<sub>4</sub>, each independently, is alkyl, substituted alkyl, alkylene, substituted alkylene, cycloalkylene, substituted cycloalkylene, arylene or substituted arylene.

Preferred rubber impact modifiers for use in polymerizable compositions in accordance with the  
50 invention include acrylic rubber modifier (Paraloid KM 334 manufactured by Rohm and Haas is an example)  
and methacrylated butadiene-styrene rubber modifiers (Metablen C223 produced by Elf Atochem is an  
example). The rubber modifiers, such as rubbery particles, are preferably added to either the resin matrix or  
the polymeric filler. Addition of rubbery particles to resin is disclosed by Cornell U.S. Patent 3,427,274.

Preferred stabilizers are butylated hydroxytoluene and the methyl ether of hydroquinone (MEHQ).

55 Compositions in accordance with the invention preferably include fillers, pigments, plasticizers, stabilizers and components of polymerization catalyst system. The fillers preferably include both organic and inorganic particulate fillers to reduce polymerization shrinkage and modify the viscosity characteristics and improve handling and molding characteristics. For example, combinations of fumed and/or ground silica or



other inorganic glasses, such as, aluminosilicate glasses known to those skilled in the dental art, may be used with organic fillers to increase viscosity and reduce tack as well as retain its prepolymerized molded shape.

Preferred fillers useful in the paste compositions of the invention include organic fillers such as particulate polymer, and inorganic filler such as glass, ceramic, or glass ceramic.

Preferably the organic filler has a particle size of less than about 200 $\mu$ m, more preferably less than about 150 $\mu$ m and most preferably less than about 80 $\mu$ m. Organic fillers include natural and synthetic polymers and copolymers which preferably are formed by atomization techniques, emulsion polymerization, bulk polymerization or suspension polymerization. In accordance with a preferred embodiment of the invention the organic filler used is a particulate polymer containing a comonomer or rubber impact modifier which will increase the mechanical properties of the resin matrix. Preferred rubber modifiers for a poly methyl methacrylate filler are methacrylated butadiene styrene materials. The organic filler polymer particles, preferably used in the compositions which form polymeric products having in order of increasing preference greater than 50,000; 100,000; 150,000; or 200,000 flexes to failure and more preferably more than 300,000 flexes to failure are discrete, non-crosslinked polymer particles which are swellable in the polymerizable Monomer at temperatures of about 15 - 70 °C. More preferably, the non-crosslinked polymer particles are alkyl methacrylate or acrylate polymers or copolymers which are swellable by the polymerizable Monomer at about temperatures of about 20 - 50 °C. Most preferably, the non-crosslinked polymer particles are copolymers of methyl methacrylate and ethyl methacrylate which are swellable by the polymerizable Monomer at temperatures of about 23 - 45 °C. The particle size of the fillers may be reduced by ball milling, shearing or by atomization.

Inorganic fillers are produced by fusion or sol gel techniques and their particle size may be reduced by ball milling, attritor milling, atomization, attention milling or precipitation. Preferred inorganic fillers include silica, quartz, borosilicates, silicious fillers, inorganic glasses, such as barium aluminum silicate, lithium aluminum silicate, strontium, lanthanum, and tantalum aluminosilicate glasses. A preferred inorganic filler is microfine amorphous silicon dioxide particulate. Silanated inorganic fillers are considered for purposes of this invention to be inorganic fillers and are also preferred. Silanated means that some of the silanol groups have been substituted or reacted with, for example, dimethyldichlorosilane to form a hydrophobic filler. The inorganic filler can also be coated with gamma methacryloxypropyl trimethoxy silane as a means of "silanating" the surface.

Preferably surface treated polymeric organic particles useful as filler in compositions in accordance with the invention have been treated with a fluorine containing gas as disclosed by Bauman et al in U.S. Patent 4,771,110 incorporated herein by reference in its entirety to generate functional reactive sites in the surface layer of the particles.

Preferably the containers used to enclose polymerizable compositions in accordance with the invention are generally cylindrical and have an oxygen permeability coefficient of at least about  $0.4 \times 10^{-10}$  cm<sup>2</sup>/sec (cm Hg). Preferably at least a 200 g quantity of polymerizable paste composition is enclosed in such container and has a shelf life of at least about one year.

Preferably dental prostheses made in accordance with the invention are substantially porosity-free. Dental prostheses are preferably formed in molds in accordance with the invention by compression molding, injection molding, pour molding or casting, such as spin casting.

Preferably, polymerizable dental compositions in accordance with the invention include from about 2 to about 95 percent by weight filler; from about 0.5 to about 50 percent by weight inorganic filler, from about 10 to about 90 percent by weight of polymerizable compounds; from about 5 to about 80 percent by weight of acrylic Monomers having a gram molecular weight in order of increasing preference of more than 200, 300, 400, 500, 1,000 or 5,000; less than about 10 percent by weight of Volatile polymerizable compounds; less than about 5 percent by weight of Low Molecular Weight polymerizable compounds.

More preferably, polymerizable dental compositions in accordance with the invention include from about 10 to about 80 percent by weight filler; from about 7 to about 30 percent by weight inorganic filler, from about 20 to about 80 percent by weight of polymerizable compounds; from about 7 to about 70 percent by weight of acrylic Monomers having a gram molecular weight greater than 300; less than about 5 percent by weight of Volatile polymerizable compounds; less than 2 percent by weight of Low Molecular Weight polymerizable compounds.

Especially preferred, polymerizable dental compositions in accordance with the invention include from about 20 to about 70 percent by weight filler; from about 7 to about 15 percent by weight inorganic filler, from about 30 to about 70 percent by weight of polymerizable compounds; from about 10 to about 60 percent by weight of acrylic Monomers having a gram molecular weight greater than 300; less than about 1 percent by weight of Volatile polymerizable compounds; less than about 1 percent by weight of Low

Molecular Weight polymerizable compounds.

Polymerizable compositions in accordance with the invention desirably include from 3 to 90 percent by weight of polymer particles which include rubber. Polymerizable compositions in accordance with the invention preferably include from 15 to 75 percent by weight of polymer particles which include rubber.

- 5 Polymerizable compositions in accordance with the invention more preferably include from 25 to 65 percent by weight of polymer particles which include rubber. Polymerizable compositions in accordance with the invention most preferably include from 35 to 55 percent by weight of polymer particles which include rubber.

- 10 In accordance with a preferred embodiment of the invention is provided a shelf stable one-component heat curable polymerizable dental paste composition including at least 5 percent by weight (and more preferably 10 percent by weight) of an acrylic Monomer having a gram molecular weight in order of increasing preference of at least 200, 400 or 1,000, at least 10 percent by weight of polymeric particles and a catalyst. These particles are effectively uncrosslinked polymer particles. The catalyst is adapted to generate free radicals during the heating curing. The composition is adapted to form a polymeric material
- 15 having a flexural fatigue life of at least 50,000 flexes to failure determined by Flexural Fatigue of Denture Bases Test. Preferably the uncrosslinked polymeric particles are swollen by the acrylic Monomer during heat curing for from about 0.25 hour to about 24 hours at from about 115°F to about 240°F and said polymeric material has an unnotched Izod impact strength of at least about 3.0 ft•lb/in as measured by Modified ASTM D256 and a flexural fatigue life of at least 100,000 flexes to failure determined by Flexural
- 20 Fatigue of Denture Bases Test.

#### Example 1A

##### Comparative Denture Base

25

Lucitone 199® denture base material, sold by Dentsply International, Inc., is mixed according to the manufacturers instructions as follows: 21 grams of Lucitone 199® denture base (sold by Dentsply International Incorporated, York, PA) polymer powder (shade Light Reddish Pink) is hand spatulated with 10 ml of Lucitone® liquid monomer to produce a fluid resin which contains about 30% by weight methyl

- becomes a "packable" dough that can be handled without sticking to the technician's hands. This dough is molded in a denture flask by compression-packing the flask in a press. Then the flask is closed in a spring clamp and immersed in a hot water curing tank. Full or complete cure is achieved with a cure cycle of 163°F for one and one half hours followed by ½ hour boil (212°F) to produce a polymeric denture base
- 35 with a flexural strength of 13,600 psi, a deflection of 0.384 inches, a modulus of elasticity of 343,000 psi, and an unnotched Izod impact strength of 4.5 ft•lb/in. as shown in Table 2.

#### Example 1B

##### Comparative Denture Base

- 40 Hi-i® denture base material, sold by Fricke Dental Manufacturing Company, Villa Park, IL is mixed according to the manufacturers instructions as follows: 30ml of Hi-i® denture base polymer powder (shade Special Fibered #1) is hand spatulated with 8.5ml of Vitacrilic® Cross Link Monomer liquid (sold by Fricke Dental Manufacturing Company, Villa Park, IL) to produce a fluid resin which contains at least 20% by weight methyl methacrylate. The fluid resin is allowed to stand at room temperature for 10 minutes until it becomes a "packable" dough. This dough is molded in a denture flask by compression packing the flask in a press. Then the flask is closed in a spring clamp and immersed in a hot water curing tank at 165°F for 1 ½ hours followed by a ½ hour at 212°F boil to produce a polymeric denture base with a flexural strength of
- 50 12,500 psi, a deflection of 0.236 inches, a modulus of elasticity of 385,000 psi, and an unnotched Izod impact strength of 3.1 ft•lbs/inch as shown in Table 2.

#### Example 1C

##### Comparative Denture Base

- 56 Triad® VLC Denture Base and Orthodontic Material sold by Dentsply International, Inc., York, PA is used according to the manufacturers instructions as follows: A 16g sheet of Triad® VLC Denture Base &

Orthodontic Material is molded into the form of a denture in a denture flask, and then light cured in a Triad® 2000™ curing unit (sold by Dentsply International Incorporated.) for 11 minutes. The denture formed has a flexural strength of 13,000 psi, a deflection of 0.18 inches, a modulus of elasticity of 505,000 psi and an unnotched Izod impact strength of 1.8 ft•lbs/in as shown in Table 2.

5

#### Example 1D

##### Comparative Crown and Bridge Material

10 Triad® VLC (Visible light curable) Provisional Material for crowns, bridges, veneers, inlays and onlays is sold by Dentsply International Inc, contains 4.8% by weight of a polyester urethane acrylate sold by Morton International which may have a molecular weight greater than 600 grams per mole. The Triad® VLC Provisional Material is used according to the manufacturer's instructions to produce a provisional crown (a temporary crown for use up to 30 days.). The one component Triad®, VLC Provisional Material is placed  
15 into a transparent crown form (which was previously shaped against a stone model of the mouth using a vacuum forming machine). Seat the transparent crown form and the Triad® VLC material firmly on the cast to shape the restoration, then cure (polymerize) in a Triad® Light Curing Unit for a total of 10 minutes. Trim and polish to complete the provisional restoration. The polymeric crown material has a flexural strength of 13,000 psi, a deflection of 0.19 inches, and an unnotched Izod impact strength of 2.0 ft lbs/inch, as shown  
20 in Table 2.

#### Example 1E

##### Comparative Orthodontic Material

25

Triad® TranSheet Translucent Light Cure Material is sold by Dentsply International Inc for fabrication of orthodontic appliances and other removable prosthodontic appliances. The Triad® TranSheet material contains 6.1% by weight of a polyester urethane acrylate sold by Morton International which may have a molecular weight greater than 600 grams per mole. TranSheet is used according to manufacturer's  
30 instructions to produce an orthodontic appliance: 1) position the orthodontic wires onto a stone cast of the patient's mouth, 2) place a single sheet of TranSheet onto the stone cast and mold with finger pressure into the desired shape, 3) place the cast and TranSheet material into a Triad® Light Curing Unit and cure for 4 minutes to partially polymerize the material, 4) remove the appliance from the cast and apply a thin layer of Triad® Air Barrier Coating to all surfaces of the TranSheet material, 5) place the appliance back into the  
35 Triad® Light Curing Unit for 6 additional minutes to complete the cure, and 6) trim and polish to complete the appliance. The polymeric orthodontic material has a flexural strength of 13,800 psi, a deflection of 0.18 inches, a flexural modulus of elasticity of approximately 450,000 psi and an un-notched Izod impact strength of 1.8 ft lb/inch, as shown in Table 2.

#### 40 Example 1F

##### Comparative Custom Impression Tray Material

Triad® VLC (visible light curable) Custom Tray Material is sold by Dentsply International Inc for  
45 fabrication of custom fit dental impression trays. The Triad® VLC Custom Tray material contains 23.56% by weight polyester urethane acrylate sold by Morton International which may have a molecular weight greater than 600 grams per mole. Triad® Custom Tray material is used according to manufacturer's instructions to produce an impression tray. Prepare a stone cast (model) of patient's mouth and block-out the undercuts and vacant tooth spaces to prevent Tray Material intrusion. After applying a release agent to the cast's  
50 surface, adapt (place by hand) a sheet of the Triad® VLC Custom Tray Material to the cast to form the custom-fit impression tray. Place the cast with the adapted tray into a Triad® Light Curing Unit and cure for 2 minutes to partially polymerize the material. Afterwards remove the tray from the cast and apply the thin layer of Triad® Air Barrier Coating to all surfaces of the tray, then cure an additional 6 minutes in the Triad® Light to complete the polymerization. Finish the custom tray by washing in tap water and adjusting  
55 the borders for best fit with a carbide bur. The polymeric VLC custom tray material has a flexural strength of 7210 psi, a deflection of 0.16 inches, a flexural modulus of elasticity of 387,000 psi, and an unnotched Izod impact strength of 1.3 ft. lb/inch, as shown in Table 2.

**Example 1G****Comparative Denture Base**

5 Hy-pro™ Lucitone® denture base material, sold by Dentsply International Inc., is mixed according to the manufacturer's instructions as follows: 21 grams of Hy-pro™ Lucitone® denture base polymer powder (shade Fibered Light) is hand spatulated with 10 mL of Lucitone® liquid monomer (sold by Dentsply International Inc.) to produce a fluid resin which contains about 30% by weight methyl methacrylate. The fluid resin is allowed to stand at room temperature for about 3 minutes until it becomes a "packable" dough  
 10 that can be handled without sticking to the technician's hands. This dough is molded in a denture flask by compression-packing the flask in a press. Then the flask is closed in a spring clamp and immersed in a hot water curing tank. Full (complete) cure is achieved with a cure cycle of 163 °F for 1-1/2 hours followed by 1/2 hour boil (212 °F) to produce a polymeric denture base with a flexural strength of 12,100 psi, a deflection of 0.21 inches, a modulus of elasticity of 392,000 psi, and an unnotched Izod impact strength of  
 15 2.9 ft lb/in as shown in Table 2.

**Example 1H****Comparative Denture Base**

20 Triad Prototype visible light curable material produced by Wilson et al is used to form a denture as follows: The Triad Prototype paste material is molded into the form of a denture in a denture flask, then light cured in a Triad® Light Curing Unit. The denture formed during this procedure has a flexural fatigue life of 8787 flexes to failure at 0.1 inch deflection (or bend distance) as is shown in Table 2.

**Example 1****Denture Base**

methacrylate, 0.4 g of dibenzoyl peroxide, 0.019 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxypropyltrimethoxysilane, 45.41 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5), 5.27 g of non-silanated, fumed silica (Aerosil 200 sold by DeGussa Corp.), 3.21 g of silanated, fumed silica (Aerosil R972 sold by DeGussa Corp.), 0.0514 g of red acetate fibers, 0.0017 g of Ultramarine Blue BC  
 35 7104 (sold by Whittaker, Clarke & Daniels, Inc., South Plainfield, NJ), 0.00059 g of Black Irox 7053 (sold by Whittaker, Clarke & Daniels, Inc.), 0.00153 g of Cromophtal Scarlet RS (sold by Ciba Geigy Corp.), 0.000592 g of Cromophtal Red BRN (sold by Ciba Geigy Corp.) and 0.0177 g of Titanox 328 (sold by Whittaker, Clarke & Daniels, Inc.) are mixed to form a one-component heat-curable denture base composition. The one component heat-curable denture base composition is molded in a denture flask, and  
 40 the flask is immersed in water at 163 °F for 1-1/2 hours and then at 212 °F for 1/2 hour to form a polymeric denture base having a flexural yield strength of 4,400 psi, a deflection at yield of 0.45 inch, a modulus of elasticity of 98,000 psi and an unnotched Izod impact strength of 4.0 ft lbs./in, as shown in Table 2.

**Example 2****Denture Base**

38.77 g of cycloaliphatic polyester urethane acrylate CN964 (Sartomer), 6.84 g of isodecyl methacrylate, 0.4 g of dibenzoyl peroxide, 0.019 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxypropyltrimethoxysilane, 45.41 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5),  
 50 5.27 g of non-silanated, fumed silica, 3.21 g of silanated, fumed silica, 0.0514 g of red acetate fibers, 0.0017 g of Ultramarine Blue BC 7104, 0.00059 g of Black Irox 7053, 0.00153 g of Cromophtal Scarlet RS, 0.000592 g of Cromophtal Red BRN and 0.0177 g of Titanox 328 are mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base composition is molded in  
 55 a denture flask, and the flask is immersed in boiling water at 212 °F for 1 hour to form a polymeric denture base having a flexural yield strength of 4,720 psi, a deflection at yield of 0.46 inch, a modulus of elasticity of 108,000 psi and an unnotched Izod impact strength of 5.4 ft lbs./in, as shown in Table 2.

**Example 3****Denture Base**

5 38.77 g of cycloaliphatic polyester urethane acrylate CN964, 6.84 g of isodecyl methacrylate, 0.4 g of dibenzoyl peroxide, 0.019 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxy propyltrimethoxy silane, 45.41 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5), 5.27 g of non-silanated, fumed silica, 3.21 g of silanated, fumed silica, 0.0514 g of red acetate fibers, 0.0017 g of Ultramarine Blue BC 7104, 0.00059 g of Black Irox 7053, 0.00153 g of Cromophtal Scarlet RS, 0.000592 g of Cromophtal Red  
 10 BRN and 0.0177 g of Titanox 328 are mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base composition is molded in a denture flask, and the flask is immersed in boiling water at 212 °F for 1-1/2 hour to form a polymeric denture base having a flexural yield strength of 4,050 psi, a deflection at yield of 0.46 inch, a modulus of elasticity of 98,700 psi and an unnotched Izod impact strength of 5.2 ft lbs./in, as shown in  
 15 Table 2.

**Example 4****Denture Base**

20 38.77 g of cycloaliphatic polyester urethane acrylate CN964, 6.84 g of isodecyl methacrylate, 0.4 g of dibenzoyl peroxide, 0.019 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxy propyltrimethoxy silane, 45.41 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5), 5.27 g of non-silanated, fumed silica, 3.21 g of silanated, fumed silica, 0.0514 g of red acetate fibers, 0.0017 g of Ultramarine Blue  
 25 BC 7104, 0.00059 g of Black Irox 7053, 0.00153 g of Cromophtal Scarlet RS, 0.000592 g of Cromophtal Red BRN and 0.0177 g of Titanox 328 are mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base composition is molded in a denture flask, and the flask is immersed in water at 163 °F for 1-1/2 hour and then at boil (212 °F) for 1-1/2 hour to form a polymeric denture base having a flexural yield strength of 4,600 psi, a deflection at yield of 0.46 inch, a  
 30 modulus of elasticity of 108,000 psi and an unnotched Izod impact strength of 4.4 ft lbs./in, as shown in Table 2.

**Example 5****Denture Base**

35 38.69 g of cycloaliphatic polyester urethane acrylate CN964 (Sartomer), 6.84 g of isodecyl methacrylate, 0.24 g of tert-butyl perisononanoate, 0.24 g of benzopinacole, 0.019 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxypropyltrimethoxy silane, 45.6 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5), 5.14 g of non-silanated, fumed silica and 3.21 g of silanated, fumed silica are  
 40 mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base composition is molded in a denture flask, and the flask is immersed in boiling water at 212 °F for 1 hour boil to form a polymeric denture base having a flexural yield strength of 4,390 psi, a deflection at yield of 0.44 inch, a modulus of elasticity of 109,000 psi and an unnotched Izod impact strength of 3.7 ft  
 45 lbs./in, as shown in Table 2.

**Example 6****Denture Base**

50 38.69 g of cycloaliphatic polyester urethane acrylate CN964 (Sartomer), 6.84 g of isodecyl methacrylate, 0.24 g of tert-butyl perisononanoate, 0.24 g of benzopinacole, 0.019 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxypropyltrimethoxy silane, 45.6 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5), 5.14 g of non-silanated, fumed silica and 3.21 g of silanated, fumed silica are  
 55 mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base composition is molded in a denture flask, and the flask is immersed in boiling water at 212 °F for 1-1/2 hours boil to form a polymeric denture base having a flexural yield strength of 4,310 psi, a deflection at yield of 0.46 inch, a modulus of elasticity of 103,000 psi and an unnotched Izod impact

strength of 4.2 ft lbs./in, as shown in Table 2.

#### Example 7

##### 5 Denture Base

38.69 g of cycloaliphatic polyester urethane acrylate CN964 (Sartomer), 6.84 g of isodecyl methacrylate, 0.24 g of tert-butyl perisononanoate, 0.24 g of benzopinacole, 0.019 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxypropyltrimethoxy silane, 45.6 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5), 5.14 g of non-silanated, fumed silica and 3.21 g of silanated, fumed silica are mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base composition is molded in a denture flask, and the flask is immersed in water at 163 °F for 1 - 1/2 hours and then at 212 °F for 1-1/2 hours to form a polymeric denture base having a flexural yield strength of 5,160 psi, a deflection at yield of 0.46 inch, a modulus of elasticity of 125,000 psi and an  
15 unnotched Izod impact strength of 4.7 ft lbs./in, as shown in Table 2

#### Example 8

##### Denture Base

34.2 g of cycloaliphatic polyester urethane acrylate CN964 (Sartomer), 11.4 g of trimethyloisopropane polyoxypropylene triacrylate CD501 (sold by Sartomer), 0.4 g of dibenzoyl peroxide, 0.02 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxypropyltrimethoxysilane, 45.6 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5), 5.13 g of non-silanated, fumed silica and 3.21 g of silanated, fumed silica are mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base composition is molded in a denture flask, and the flask is immersed in water at 163 °F for 1-1/2 hours and then at boil (212 °F) for 1/2 hour to form a polymeric denture base having a flexural yield strength of 5,520 psi, a deflection at yield of 0.439 inch, a modulus of elasticity of 146,500 psi and an unnotched Izod impact strength of 3.8 ft lbs./in, as shown in Table 2.

#### Example 9

##### Teeth

26.93 g of cycloaliphatic polyester urethane acrylate CN964 (Sartomer), 6.84 g of cycloaliphatic polyester urethane acrylate CN963 (sold by Sartomer), 11.4 g of trimethyloisopropane polyoxy propylene triacrylate CD501 (sold by Sartomer), 0.4 g of dibenzoyl peroxide, 0.02 g of butylated hydroxytoluene, 0.008 g of gamma-methacryloxypropyltrimethoxysilane, 45.6 g of poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5), 5.13 g of non-silanated, fumed silica and 3.21 g of silanated, fumed silica are mixed to form a tooth material. The tooth material is injected into tooth-shaped cavities in a two-part metal mold by a transfer molding technique at a pressure of 500 psi and cured at a temperature of 250 °F for six minutes to form polymeric teeth. After the heat curing cycle, the metal mold and the teeth are cooled at about 40-45 °F for six minutes. The polymeric teeth have a modulus of elasticity of 213,000 psi and an unnotched Izod impact strength of 3.1 ft•lb/in, as shown in Table 2.

#### Example 10

##### Injection-Molded Denture Base

30 g of one-component heat-curable denture base formed by following Example 1 is injected into a mold contained within a flask, and the flask is immersed in boiling water (212 °F) for 1/2 hour to form a polymeric denture base.

**Example 11****Denture Base**

- 5 A. Plasma treatment of polymeric filler 131.5 g of poly(methyl methacrylate-co-ethyl methacrylate: 54.5:45.5) was gas plasma treated to create a bondable (reactive) surface by Advanced Plasma Systems, Inc. (St. Petersburg, Florida).
- B. Preparation of the denture base
- 45.6 g of plasma treated poly(methyl methacrylate-co-ethyl methacrylate: 54.5:45.5) from section 11-
- 10 (A) was mixed to form a one component, heat-curable denture base material by substituting the plasma treated polymer in Example 1. The one component heat-curable denture base composition is molded in a denture flask, and the flask is immersed in water at 163 °F for 1-1/2 hours and then at 212 °F for 1/2 hour to form a polymeric denture.

**15 Example 12****Denture Base**

- 32.97g of 7,7,9 - trimethyl-4,13-dioxo-3,14-dioxo-5,12-diazahexadecane-1,16-dioldimethacrylate, 10.0g of
- 20 cycloaliphatic polyester urethane acrylate CN 964 (Sartomer), 0.4 g of dibenzoyl peroxide, 0.02 g of butylated hydroxytoluene, 0.01 g of gamma-methacryloxypropyltrimethoxysilane, 47.84 g of poly (methyl methacrylate-co-n butyl methacrylate-co-methacrylated-butadiene styrene rubber: 92.1 : 2.5 : 5.4), 5.39 g of non-silanated, fumed silica and 3.37 g of silanated, fumed silica are mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base composition is molded in
- 25 a denture flask, and the flask is immersed in water at 163 °F for 1-1/2 hours and then at boil (212 °F) for 1/2 hour to form a polymeric denture base having a flexural strength of 13,900 psi, a deflection at break of 0.32 inch, a modulus of elasticity of 374,000 psi and an unnotched Izod impact strength of 2.8 ft lbs./in, as shown in Table 2.

**30 Example 13****Denture Base**

- 32.97 g of 7,7,9-trimethyl-4,13-dioxo-3,14-dioxo-5,12-diazahexadecane-1,16- dioldimethacrylate, 10.0 g
- 35 of trimethylolpropane polyoxyethylene triacrylate SR502 (sold by Sartomer), 0.40 g of dibenzoyl peroxide, 0.02 g of butylated hydroxytoluene, 0.01 g of gamma-methacryloxypropyltrimethoxy-silane, 47.84 g of poly (methyl methacrylate-co-n butyl methacrylate-co-methacrylated-butadiene styrene rubber: 92.1 : 2.5 : 5.4), 5.39 g of non-silanated fumed silica and 3.37 g of silanated, fumed silica are mixed to form a one component heat-curable denture base composition. The one component heat-curable denture base com-
- 40 position is molded in a denture flask, and the flask is immersed in water at 163 °F for 1-1/2 hours and then at boil (212 °F) for 1/2 hour to form a polymeric denture base having a flexural strength of 14,100 psi, a deflection of break of 0.41 inch, a modulus of elasticity of 376,000 psi and an unnotched Izod impact strength of 4.0 ft•lbs./in, as shown in Table 2.

**45 Example 14****Denture Base**

- 32.97 g of 7,7,9-trimethyl-4,13-dioxo-3,14-dioxo-4,12-diazahexadecane-1,16-dioldimethacrylate, 10.0 g of
- 50 trimethylolpropane polyoxyethylene triacrylate SR 499 (sold by Sartomer), 0.40 g of dibenzoylperoxide, 0.02 g of butylated hydroxy toluene, 0.01 g of gamma-methacryloxypropyltrimethoxy-silane, 47.84 g of poly (methylmethacrylate-co-n butyl methacrylate-co-methacrylated butadiene styrene rubber: 92.1 : 2.5 : 5.4), 5.39 g of non-silanated fumed silica and 3.37 g of silanated fumed silica are mixed to form a one-component heat-curable denture base composition. The one component heat-curable denture base com-
- 55 position is molded in a denture flask, and the flask is immersed in water at 163 °F for 1-1/2 hours and then at boil (212 °F) for 1/2 hour to form a polymeric denture base having a flexural strength of 14,500 psi, a deflection at break of 0.40 inches, a modulus of elasticity of 373,000 psi and an unnotched Izod impact strength of 3.3 ft lbs/in as shown in Table 2.

The composition of Examples 1, 5, 8, and 9 are shown in Table 1. The compositions of Examples 12, 13, and 14 are shown in Table 1A.

Table 1. Composition of Denture Base

Example		1	5	8	9
	Composition				
Oligomers	cycloaliphatic polyester urethane acrylate (CN964)	38.77	38.69	34.2	26.93
	cycloaliphatic polyester urethane acrylate (CN963)	---	---	---	6.84
	7,7,9-trimethyl-4,13-dioxo-3,14-dioxo-5,12-diazahexadecane-1,16-dioldimethacrylate	---	---	---	---
Diluent Monomers	isodecyl methacrylate	6.84	6.84	---	---
	trimethylolpropane polyoxypropylene triacrylate (CD 501)	---	---	11.4	11.4
	trimethylolpropane polyoxyethylene triacrylate (SR502)	---	---	---	---
	Trimethylolpropane polyoxyethylene triacrylate (SR499)	---	---	---	---
Catalyst	dibenzoyl peroxide	0.4	---	0.4	0.4
	tert-butyl perisononanoate	---	0.24	---	---
	benzopinacole	---	0.24	---	---
Coupling Agent	gamma-methacryloxypropyltrimethoxysilane	0.008	0.008	0.008	0.008
	(2-hydroxy-4-methoxyphenyl)-benzophenone	---	---	---	---
Polymer Particles	poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5)	45.41	45.6	45.6	45.6
	Poly(methyl methacrylate-co-n butylmethacrylate-co-methacrylated butadiene styrene rubber: 92.1 : 2.5 : 5.4)	---	---	---	---
Filler	non-silanated, fumed silica (Aerosil 200)	5.27	5.14	5.13	5.13
	silanated, fumed silica (Aerosil R972)	3.21	3.21	3.21	3.21
Pigments	Red Acetate Fibers	0.0514	---	---	---
	Ultramarine Blue BC 7104	0.0017	---	---	---
	Black Irox 7053	0.00059	---	---	---
	Cromophtal Scarlet RS	0.00153	---	---	---
	Cromophtal Red BRN	0.000592	---	---	---
	Titanox 328	0.0177	---	---	---



Table 1A. Composition of Denture Base

Example		12	13	14
	Composition			
5	Oligomers			
	cycloaliphatic polyester urethane acrylate (CN964)	10.0	---	---
	cycloaliphatic polyester urethane acrylate (CN963)	---	---	---
10	7,7,9-trimethyl-4,13-dioxo-3,14-dioxo-5,12-diazahexadecane-1,16-dioldimethacrylate	32.97	32.97	32.97
	Diluent Monomers			
	isodecyl methacrylate	---	---	---
15	trimethylolpropane polyoxypropylene triacrylate (CD 501)	---	---	---
	trimethylolpropane polyoxyethylene triacrylate (SR502)	---	10.0	---
20	Trimethylolpropane polyoxyethylene triacrylate (SR499)	---	---	10.0
	Catalyst			
	dibenzoyl peroxide	0.40	0.40	0.40
	tert-butyl perisononanoate	---	---	---
25	benzopinacole	---	---	---
	Stabilizer and Coupling Agent			
	butylated hydroxytoluene	0.02	0.02	0.02
	gamma-methacryloxypropyltrimethoxy silane	0.01	0.01	0.01
30	(2-hydroxy-4-methoxyphenyl) benzophenone	---	---	---
	Polymer Particles			
	poly(methyl methacrylate-co-ethyl methacrylate:54.5:45.5)	---	---	---
35	Poly(methyl methacrylate-co-n butylmethacrylate-co-methacrylated butadiene styrene rubber: 92.1 : 2.5 : 5.4)	47.84	47.84	47.84
	Filler			
	non-silanated, fumed silica (Aerosil 200)	5.39	5.39	5.39
	silanated, fumed silica (Aerosil R972)	3.37	3.37	3.37
40	Pigments			
	Red Acetate Fibers	---	---	---
	Ultramarine Blue BC 7104	---	---	---
	Black Irox 7053	---	---	---
	Cromophtal Scarlet RS	---	---	---
	Cromophtal Red BRN	---	---	---
45	Titanox 328	---	---	---

Table 2 shows the flexural strength, deflection, modulus of elasticity and unnotched Izod impact strength and/or flexural fatigue life for the polymeric products of prior art comparative Examples 1A through 1H as well as Examples 1 through 9 and 12 through 14 in accordance with the invention.

Table 2. Physical Properties of Polymeric Dental Products

Example	Flexural Strength, psi	Deflection, inches per unit deformation	Modulus of Elasticity, psi	Unnotched Izod Impact Strength, ft•lbs/in	Median number of flexes to failure at 0.1 inch (2.5 mm) deflection (bend distance)	Weight percent of Low Molecular Weight Monomer
1A	13,600	0.384	343,000	4.5	13,000	approximately 25
1B	12,500	0.236	385,000	3.1	19,300	approximately 25
1C	13,000	0.18	505,000	1.8	2,747	0
1D	13,000	0.19	---	2.0	estimated to be less than 5,000	0
1E	13,800	0.18	450,000	1.8	estimated to be less than 5,000	0
1F	7,210	0.16	387,000	1.3	estimated to be less than 5,000	0
1G	12,100	0.21	392,000	2.9	115,700	approximately 25
1H	---	---	---	---	8,787	0
1	4,400	0.45	98,000	4.0	greater than 1,088,000	0
2	4,720	0.46	108,000	5.4	approx. greater than 1,000,000	0
3	4,050	0.46	98,700	5.2	approx. greater than 1,000,000	0
4	4,600	0.46	108,000	4.4	approx. greater than 1,000,000	0
5	4,390	0.44	109,000	3.7	---	0
6	4,310	0.46	103,000	4.2	---	0
7	5,160	0.46	125,000	4.7	---	0
8	5,520	0.439	146,500	3.8	---	0
9	---	---	213,000	3.1	---	0
12	13,900	0.32	374,000	2.8	26,500	0
13	14,100	0.41	376,000	4.0	59,500	0
14	14,500	0.40	373,000	3.3	---	0

Some prior art denture base material includes Low Molecular Weight Monomer and forms polymeric material which has more than 50,000 flexes to failure, as is shown in Example 1G. Those Denture base compositions used in the prior art which include at least one polymerizable acrylic Monomer having at least one acrylic moieties and a gram molecular weight of at least about 200 form polymeric material which has less than about 10,000 flexes to failure using the Flexural Fatigue of Denture Bases Test, as is shown in Example 1C. The superior denture base compositions in accordance with the preferred embodiment of the invention include at least one polymerizable acrylic Monomer having at least one and more preferably at least two acrylic moieties and a gram molecular weight of at least 200 and form polymeric material which has more than 20,000 flexes to failure using the Flexural Fatigue of Denture Bases Test.

A preferred embodiment of the invention provides polymeric dental products having an unnotched Izod impact strength preferably of at least 2.5 and more preferably at least 3.0 ft•lbs/in and preferably at least 50,000 flexes to break formed from polymerizable compositions which are free of Low Molecular Weight Monomers. The prior art does not provide polymeric dental products having an unnotched Izod impact strength of at least 3.0 ft•lb/in and at least 50,000 flexes to break formed from a polymerizable composition

which is free of Low Molecular Weight Monomer. The polymerizable compositions of prior art comparative Examples 1A, 1B and 1G each contain at least 20 percent of methyl methacrylate which is a Low Molecular Weight Monomer. The polymeric dental products of prior art comparative Examples 1C, 1D, 1E and 1F each have an unnotched Izod impact strength substantially less than 2.5 ft•lb/in. The polymeric dental products of Examples 1D, 1E, and 1F are expected to have less than 5,000 flexes to failure using the Flexural Fatigue of Denture Bases Test due to their low deflection to permanent deformation and similarity of the polymers to that of Example 1C.

The products of the composition in accordance with the invention as exemplified by Example 1 through 8 have bend distance (deflection) to permanent deformation which is higher than the product of prior art Example 1A, 1B, 1C, 1D, 1E 1F and 1G.

The flexural fatigue life of the products of compositions in accordance with the invention as exemplified by Example 1 are unexpectedly superior to that of all known products of the prior art as exemplified by comparative Examples 1A, 1B, 1C and 1G. The 2.5 mm (0.1 inch) bend distance in the flexural fatigue test is an accelerated test since movement during use in-the-mouth is purportedly less than 1 mm. The more than 1,088,000 flexes to failure for the product of Example 1 on our test machine is comparable to at least several millions of flexes at less than 1 mm of bend in the actual use of a denture. The median number of flexes to failure of the heat-curable denture base material of the invention is an exceptionally high number of bend cycles before breaking compared to the products of prior art denture base materials formed in Examples 1A, 1B, 1C and 1G.

The flexural strengths of the products of the compositions in accordance with the invention as exemplified by Examples 12, 13, and 14 are as high as or higher than prior art Examples 1A, 1B, 1C, 1D, 1E, 1F and 1G. The flexural fatigue lives of the products of Examples 12 and 13 are superior to those of prior art Examples 1A, 1B and 1C.

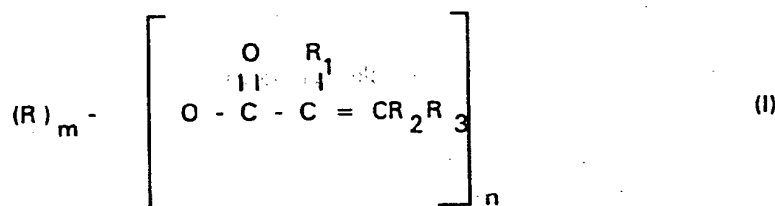
Heat-curable denture material of the invention preferably includes benzoyl peroxide (BPO), or tert butyl perisononanoate (TBPIN) or benzopinacole.

It should be understood that while the present invention has been described in considerable detail with respect to certain specific embodiments thereof, it should not be considered limited to such embodiments but may be used in other ways without departure from the spirit of the invention and the scope of the appended claims.

### Claims

1. A dental prosthesis comprising polymeric material formed by heat curing a one-component polymerizable composition for from about 0.25 hour to about 24 hour at from about 115°F to about 240°F in a chamber of a dental prosthesis mold having an inner wall with a dental prosthesis shape, said composition comprising polymerizable acrylic compounds, said polymerizable compounds comprising at least one polymerizable acrylic Monomer having at least one acrylic moiety and a gram molecular weight of at least 200, said polymeric material having at least 20,000 flexes to failure using the Flexural Fatigue of Denture Bases Test and an unnotched Izod impact strength of at least 2.5 ft•lb/in as measured by Modified ASTM D256.
2. The dental prosthesis of claim 1 wherein said acrylic Monomer having at least two acrylic moieties and comprises at least about 5 percent by weight of said polymerizable compounds at least 50,000 flexes to failure using the Flexural Fatigue of Denture Bases Test and an unnotched Izod impact strength of at least 3.0 ft•lb/in as measured by Modified ASTM D256.
3. The dental prosthesis of claim 1 wherein said composition further comprises polymeric particles, said polymeric particles being swollen with said polymerizable acrylic compound during said heat curing, and wherein said polymerizable compounds further comprise less than 30 percent by weight of Volatile compounds having a gram molecular weight of less than 400 and said polymerizable composition further comprises at least 1 percent by weight of polymer particles, said polymer particles, said polymer particles comprise rubber or rubber modifier.
4. The dental prosthesis of claim 1 wherein said polymerizable compounds comprise less than 5 percent by weight of Low Molecular Weight polymerizable acrylic compounds having a gram molecular weight of less than 200.

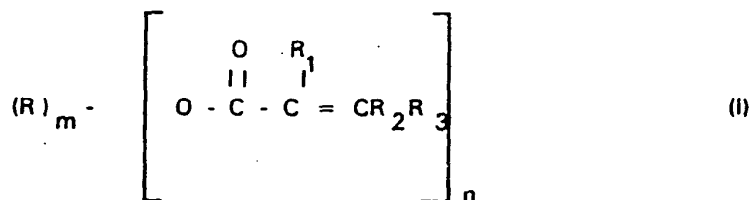
5. The dental prosthesis of claim 2 wherein said acrylic Monomer comprises at least 10 percent by weight of said polymerizable compounds and said polymerizable composition is heat cured for from about 0.5 hour to about 15 hours at from about 140 °F to about 220 °F..
6. The dental prosthesis of claim 2 wherein said polymerizable compounds comprise less than 20 percent by weight of Volatile compounds.
7. The dental prosthesis of claim 2 wherein said polymerizable compounds comprise less than one percent by weight of Low Molecular Weight polymerizable acrylic compounds having a gram molecular weight less than 150.
8. The dental prosthesis of claim 1 wherein said acrylic Monomer comprises at least 20 percent by weight of said polymerizable composition.
9. The dental prosthesis of claim 1 wherein said polymerizable compounds further comprise less than 10 percent by weight of Volatile compounds and said polymeric material has at least 50,000 flexes to failure.
10. The dental prosthesis of claim 1 wherein said polymerizable compound comprise less than 0.5 percent by weight of Low Molecular Weight polymerizable compounds having a gram molecular weight less than 130.
11. The dental prosthesis of claim 1 wherein said prosthesis is a denture base, artificial tooth, filling, crown, bridge or inlay.
12. The dental prosthesis of claim 8 wherein said prosthesis is a denture base artificial tooth, filling, crown, bridge or inlay.
13. The dental prosthesis of claim 1 wherein said composition further comprises polymeric filler particles, and said impact strength is at least 3.5 ft-lb/in as determined by Modified ASTM D256.
14. The dental prosthesis of claim 1 wherein said polymerizable acrylic Monomer has at least two acrylic moieties and is within the scope of the general formula:



wherein R is an acrylic-free organic moiety which is at least 60 grams per molecule, R<sub>1</sub> is hydrogen, halogen, alkyl, substituted alkyl or cyano radical, R<sub>2</sub> and R<sub>3</sub> each independently is hydrogen or halogen and n is an integer from 1 to 6 and m is an integer from 1 to 1000.

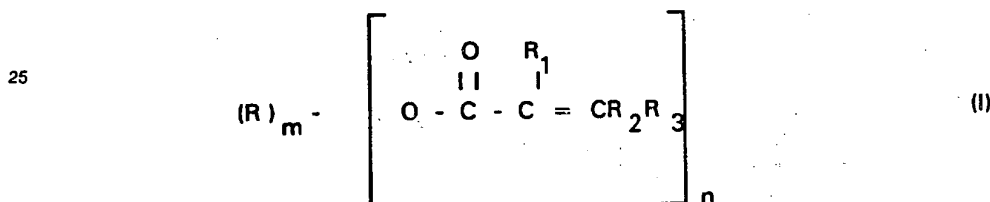
15. The dental prosthesis of claim 1 wherein said polymeric material has a flexural fatigue life of at least 1,000,000 flexes to failure determined by Flexural Fatigue of Denture Bases Test.
16. The dental prosthesis of claim 1 wherein said molecular weight of said acrylic Monomer is at least 300 g/mol.
17. The dental prosthesis of claim 1 wherein said molecular weight of said acrylic Monomer is at least 400 g/mol.
18. The dental prosthesis of claim 1 wherein said molecular weight of said acrylic Monomer is at least 500 g/mol.

19. The dental prosthesis of claim 1 wherein said molecular weight of said acrylic Monomer is at least 1,000 g/mol.
20. The dental prosthesis of claim 1 wherein said molecular weight of said acrylic Monomer is at least 5,000 g/mol.
21. The dental prosthesis of claim 1 wherein said polymerizable comprises a polymer particles which are swellable by said monomer at about 23 °C and about 760 mm of Hg..
22. A denture base, comprising:  
 a polymeric material formed by heat curing a one-component polymerizable composition in a chamber of a mold having an inner wall with a surface which forms the shape of said dental prosthesis, said heat curing being for from about 0.25 hours to about 24 hours at from about 115 °F to about 240 °F, said polymerizable composition comprising at least one polymerizable acrylic Monomer having at least two acrylate moieties, and a gram molecular weight of at least 200, said polymeric material having an unnotched Izod impact strength of at least 3.0 ft·lb/in as measured by Modified ASTM D256, a flexural fatigue life of at least 50,000 flexes to failure measured by the Flexural Fatigue of Denture Bases Test.
23. The denture base of claim 22 wherein said polymerizable acrylic Monomer is within the scope of the general formula:



- wherein R is an acrylic-free organic moiety which is at least 60 grams per molecule, R<sub>1</sub> is hydrogen, halogen, alkyl, substituted alkyl or cyano radical, R<sub>2</sub> and R<sub>3</sub> each independently is hydrogen or halogen and n is an integer from 1 to 6 and m is an integer from 1 to 1000.
24. The denture base of claim 22 wherein the molecular weight of said acrylic Monomer is at least 300 g/mol.
25. The denture base of claim 22 wherein said molecular weight is at least 400 g/mol, and said polymerizable composition further comprises particles of polymer, said polymer being swellable by said monomer at about 23 °C and about 760 mm Hg.
26. The denture base of claim 22 wherein said molecular weight of said acrylic Monomer is at least 500 g/mol.
27. The denture base of claim 22 wherein said molecular weight of said acrylic Monomer is at least 600 g/mol.
28. The denture base of claim 22 wherein said molecular weight of said acrylic Monomer is at least 1,000 g/mol.
29. The denture base of claim 22 wherein said molecular weight of said acrylic Monomer is at least 5,000 g/mol.
30. The denture base of claim 22 wherein said acrylic Monomer comprises at least 20 percent by weight of said polymerizable composition.

31. The denture base of claim 22 wherein said acrylic polymerizable composition comprises less than 10 percent by weight of Volatile compounds.
32. A denture comprising:  
 5 a denture base and at least one artificial tooth, said denture base comprising a polymeric material having a flexural fatigue life of at least 200,000 flexes to failure determined by the Flexural Fatigue of Denture Bases Test.
33. The denture of Claim 32 wherein said polymeric material has a flexural fatigue of at least 150,000  
 10 flexes of failure determined by the Flexural Fatigue of Denture Bases Test.
34. A method of making a denture, comprising compression molding while heat curing a one-component polymerizable composition for from about 0.25 hour to about 24 hours at from about 115°F to about  
 15 240°F while enclosed by a mold chamber wall having a denture shape to form a denture, said polymerizable composition having a polymerizable monomer with a molecular weight greater than 300, a free radical generating catalyst, said acrylic Monomer being adapted to form a polymeric material having an unnotched Izod impact strength of at least about 3.0 ft•lb/in as measured by Modified ASTM D256, and at least 50,000 flexes to failure measured by the Flexural Fatigue of Denture Bases Test.
- 20 35. The method of claim 34 wherein said polymerizable acrylic Monomer is within the scope of the general formula:



wherein R is an acrylic-free organic moiety which is at least 60 grams per molecule, R<sub>1</sub> is hydrogen, halogen, alkyl, substituted alkyl or cyano radical, R<sub>2</sub> and R<sub>3</sub> each independently is hydrogen or halogen and n is an integer from 1 to 6 and m is an integer from 1 to 1000.

- 35 36. The method of claim 34 wherein said polymeric material has a flexural fatigue of at least 100,000 flexes to failure determined by the Flexural Fatigue of Denture Bases Test.
37. The method of claim 34 wherein said molecular weight of said acrylic Monomer is at least 300 g/mol.
- 40 38. The method of claim 34 wherein said molecular weight of said acrylic Monomer is at least 400 g/mol.
39. The method of claim 34 wherein said molecular weight of said acrylic Monomer is at least 500 g/mol.
- 45 40. A method of making a denture base, comprising:  
 heat curing a polymerizable composition having a polymerizable acrylic Monomer having a gram molecular weight of at least 400 for from about 0.25 hour to about 24 hours at from about 115°F to about 240°F in a chamber of a dental prosthesis mold with an inner wall having a denture base shape, said acrylic Monomer being adapted to form a polymeric material having an unnotched Izod impact  
 50 strength of at least about 3.0 ft•lb/in as measured by Modified ASTM D256, and at least 50,000 flexes to failure by the Flexural Fatigue of Denture Bases Test, compression molding and heat curing said polymerizable composition to form a denture base.
41. A method of making a one component denture base, comprising:  
 55 heat curing a polymerizable composition having at least 5 percent by weight a polymerizable acrylic Monomer having a gram molecular weight greater than 200 for from about 0.25 hour to about 24 hours at from about 115°F to about 240°F in a chamber of a dental prosthesis mold with an inner wall having a denture base shape, said acrylic Monomer being adapted to form a polymeric material having

an unnotched Izod impact strength of at least about 3.0 ft•lb/in as measured by Modified ASTM D256, and at least 50,000 flexes to failure by the Flexural Fatigue of Denture Bases Test, molding and heat curing said polymerizable composition to form a denture base.

- 5 42. A shelf stable one-component heat curable polymerizable dental paste composition comprising:  
at least 5 percent by weight of an acrylic Monomer having a gram molecular weight of at least 200,  
at least 10 percent by weight of polymeric particles and a catalyst, said polymeric particles effectively  
being uncrosslinked polymer particles, said composition being adapted to form a polymeric material  
having a flexural fatigue life of at least 20,000 flexes to failure determined by Flexural Fatigue of  
10 Denture Bases Test, said composition comprising less than 10 percent by weight of Low Molecular  
Weight Monomer.
43. The composition of claim 42 wherein said composition comprising less than 5 percent by weight of Low  
Molecular Weight Monomer, said acrylic Monomer has a gram molecular weight of at least 400, said  
15 catalyst being adapted to generate free radicals during said heating curing, and said uncrosslinked  
polymeric particles are swollen or partially dissolved by said acrylic Monomer during heat curing for  
from about 0.25 hour to about 24 hours at from about 115°F to about 240°F and said polymeric  
material has an unnotched Izod impact strength of at least about 3.0 ft•lb/in as measured by Modified  
ASTM D256 and a flexural fatigue life of at least 100,000 flexes to failure determined by Flexural  
20 Fatigue of Denture Bases Test.
44. The dental composition of claim 42 wherein said polymeric material has a flexural fatigue life of at least  
100,000 flexes to failure determine by Flexural Fatigue of Denture Bases Test and an unnotched Izod  
25 impact strength of at least 2.5 ft•lb/in as measured by Modified ASTM D256.
45. The dental composition of claim 42 wherein said polymeric material has a flexural fatigue life of at least  
150,000 flexes to failure determine by Flexural Fatigue of Denture Bases Test and said composition  
percent by weight of said acrylic Monomer further comprising of at least 20 and has a vapor pressure  
of less than 10 mm Hg at 23°C.
- 30 46. The dental composition of claim 42 wherein said composition further comprise benzoyl peroxide, tert  
butyl perisononanoate or benzopinacole has a vapor pressure of less than 5 mm Hg at 23°C.
47. The dental composition of claim 42 wherein said composition has a viscosity of at least 10,000  
35 centipoise.
48. The dental composition of claim 42 wherein said composition further comprises pigment.
49. The dental composition of claim 42 wherein said composition is light reddish pink in color.
- 40 50. The dental composition of claim 42 wherein said particles are swollen by said acrylic Monomer and  
said acrylic Monomer has a gram molecular weight of at least 1,000.
51. The dental composition of claim 42 wherein said particles are partially dissolved by said acrylic  
45 Monomer.
52. The dental composition of claim 42 wherein said composition having a mass of from at least 200g, and  
said composition being effective to maintain said acrylic Monomer without polymerization for at least  
50 six months at 23°C.
53. The dental composition of claim 42 wherein said polymeric material has an unnotched Izod impact  
strength of at least 4.0 ft lbs/in as measured by Modified ASTM D256.
54. The dental composition of claim 53 wherein said acrylic Monomer comprises at least about 10 percent  
55 by weight of said polymerizable compounds and said polymeric material is adapted to withstand at  
least 1,000,000 flexes to break in the Flexural Fatigue of Denture Bases Test.

55. The dental composition of claim 53 wherein polymeric material is polymerized by heat curing and said polymerizable compounds further comprise less than 30 percent by weight of Volatile and said polymerizable compounds comprise at least 1 percent by weight of said composition.

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European Patent  
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## EUROPEAN SEARCH REPORT

Application Number  
EP 94 10 9740

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. CL.5)
X	EP-A-0 346 707 (BAYER)  * the whole document *	1-14, 16-21, 42-55	A61K6/083 A61K6/09
X	EP-A-0 427 300 (DENTSPLY)  * claims; examples *	1-4, 22-31, 42-55	
D	& US-A-4 711 913		
D	& US-A-4 863 977		
D	& US-A-4 551 486		
X	EP-A-0 059 525 (DENTSPLY) * example 10 *	34	
D	& US-A-4 698 373		
A	US-A-5 183 834 (K. GORLICH)		
A	DE-A-15 16 455 (WILLIAMS GOLD REFINING CO)		
			TECHNICAL FIELDS SEARCHED (Int. CL.5)
			A61K
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 30 September 1994	Examiner Cousins-Van Steen, G
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application I : document cited for other reasons ----- & : member of the same patent family, corresponding document	

